

Date: Monday, 04/02/2008 3:13:01 PM
User: Dominique Dube

Process Sheet

| | | | |
|-----------------------|---|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 407 STEP ASSEMBLY |
| Job Number | : 37012 | | |
| Estimate Number | : 11795 | | |
| P.O. Number | : | Part Number | : D206628033 |
| This Issue | : 04/02/2008 S.O. No. : | Drawing Number | : N/A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 25/01/2008 Type : LARGE FAB ASSY | Drawing Revision | : |
| Previous Run | : 33923 | Material | : |
| Written By | : <u>W</u> | Due Date | : 10/03/2008 Qty: 4 Um: Each |
| Checked & Approved By | : <u>W</u> | | |
| Comment | : Est Rev:D As Per Ecn 766 06-01-06 JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | | | | | | | | |
|--|-----------------------|----------------------------------|-------------------|-----|-------------|-------------|-------|---|---------|--------------|-------------------|
| 1.0 | DC | DOCUMENT CONTROL | (4) | | | | | | | | |
| | | | | | | | | | | | |
| <p>Comment: DOCUMENT CONTROL</p> <p>Photocopy blue file and type labels as per PPP D206-628-033 CHG 002 003 per ECN 1118 u</p> | | | | | | | | | | | |
| 2.0 | 37012A | FLOAT STEP ASSEMBLY LH (206/407) | | | | | | | | | |
| | | | | | | | | | | | |
| <p>Comment: Sub-Component SUB-ASSEMBLY</p> <p>206B STEP ASSY, LH</p> <p>D2842-041 B 37012A</p> | | | | | | | | | | | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | | | | | | | | | |
| | | | | | | | | | | | |
| <p>Comment: PACKAGING RESOURCE #1</p> <p>UPDATED AS PER ECN 1118, D206-268-033 CHG NUM. 003</p> | | | | | | | | | | | |
| 4.0 | D27313 | Mounting Lug | | | | | | | | | |
| | | | | | | | | | | | |
| <p>Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>4</td><td>D2731-3</td><td>Mounting Lug</td><td>B37335</td></tr> </table> <p><u>B37335</u> AS 08/03/19 (x4)</p> | | | | Qty | Part Number | Description | Batch | 4 | D2731-3 | Mounting Lug | B37335 |
| Qty | Part Number | Description | Batch | | | | | | | | |
| 4 | D2731-3 | Mounting Lug | B37335 | | | | | | | | |
| 5.0 | D28441 | Arm | | | | | | | | | |
| | | | | | | | | | | | |
| <p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)</p> <p>Pick: Packing Kit</p> <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>2</td><td>D2844-1</td><td>Arm</td><td><u>B37337</u></td></tr> </table> <p>AS 08/03/19 (x4)</p> | | | | Qty | Part Number | Description | Batch | 2 | D2844-1 | Arm | <u>B37337</u> |
| Qty | Part Number | Description | Batch | | | | | | | | |
| 2 | D2844-1 | Arm | <u>B37337</u> | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 04/02/2008 3:13:01 PM
User: Dornique Dube

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37012

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2844-3 Arm B37338

AS 08/03/19 (x4)

7.0

D2732030

Rubber Cushion



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part # Description Batch
8 D2732-030 RUBBER CUSHION 34717

Error
All Same Batch
32 pieces to take out

AS 08/03/19 (x4)

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D3394-041 LUG ASS,Y B34833

AS 08/03/19 (x4)

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN3C4A Bolt M105559

AS 08/03/19 (x4)

10.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN4C14A Bolt M107087

AS 08/03/19 (x4)

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C15A Bolt 103915

AS 08/03/19 (x4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:57:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37012

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 12.0000 EACH(s)

Pick:

Qty Part Number Description Batch
3 AN960C10 WASHER

Batch

M106302

AS 08/03/19 (x4)

13.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number Description Batch
24 AN960C416L Washer

Batch

~~M106785~~ M105793 x29 M107242 x67

AS 08/03/19 (x4)

14.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number Description Batch
24 NAS1515H4L Washer

Batch

M105408 x22 M107008 x74

AS 08/03/19 (x4)

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch
12 MS21043-4 Nut (or MS21042-4)

Batch

M107101 x22 ~~M107008~~

AS 08/03/19 (x4)

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 NAS1515H3 Washer

Batch

M106431

AS 08/03/19 (x4)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

001 03/20 (x4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 26/09/20
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:57:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37012

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-033

Location:

PPP Rev:

Rev D

AS 08/03/20

(4)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/20

(4)

Job Completion



08-03-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

628033

Dart Aerospace Ltd.

Date: Friday, 1/25/2008 10:57:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY LH (206/407)
 Job Number : 37012A
 Estimate Number : 11664
 P.O. Number :
 This Issue : 1/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2842041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2842 REV B
 Previous Run : 33921A Material :
 Due Date : 3/10/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JA 080125
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

| Qty | Part # | Description | Batch: |
|-----|------------|-------------|---------------|
| 1 | D2622-120C | Extrusion | <u>B36618</u> |

Check Material for any Dents or Defects

SAD 08/02/27

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

08/02/27

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------------|
| 2 | D2734 | End Cap | <u>336520</u> |

JE 08-03-10 4

4.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:57:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 37012A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 D3459-3 Lug

337347

08-03-10

4

5.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-1 Lug

337346

08-03-10

4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842

A/R AL Rod Batch: M105058

M106762

2-Grind end cap weld flush

SAD 08/03/11

(4)

08-03-10

4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/11 4X LH

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-03-11 (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. h

08/03/11

(4X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-12

4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:57:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 37012A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M106834

2-Grind end cap weld flush.

08-03-12 4
SAW 08/03/13 ④

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

④ 08-03-13 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

④ 08/03/13 ④

14.0

POWDER COATING

POWDER COATING



M107005
m-h

08/03/14



④
④

Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3.5.1

④ 08-03-13

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

④ 08/03/17 ④

16.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3 NAS1329C3KB130

Insert

~~M106785 (x1)~~
~~M107007 (x1)~~

m 106951

Feb

④
Feb 08/03/17

17.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07

Screw

M106785 (x1) *m/07008 (x11)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 28/03/00
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:57:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 37012A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

m/106516.

FL

19.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

m/107242.

FL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: m/107385

FL 08/03/17 (4)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 08/03/18 (4) (4) (4)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP: 37012

AS

08/03/20

(x4)

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FL 08/03/20

Job Completion



FL 08/03/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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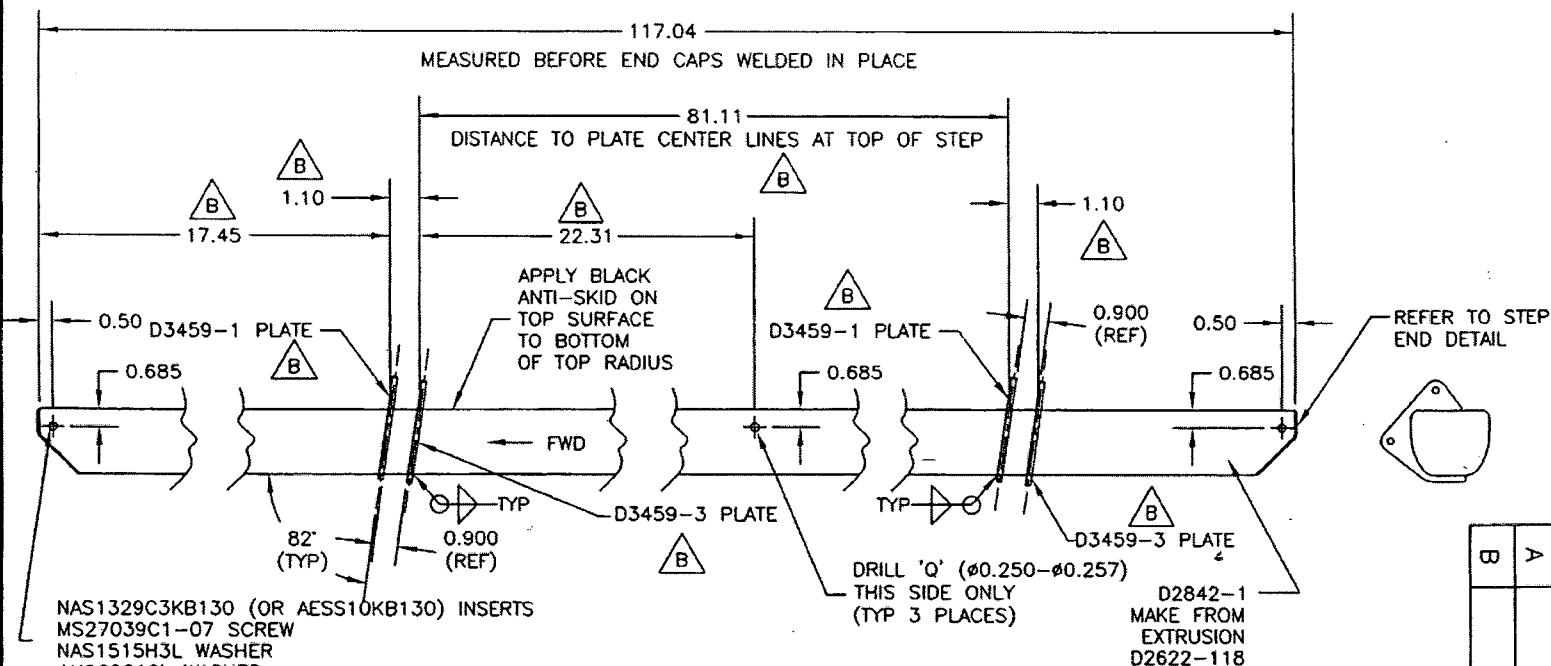
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART



NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|----------|----------|---------------------------------|------------------|
| X | X | D2842-041 | LH STEP ASSEMBLY |
| | | D2842-042 | RH STEP ASSEMBLY |
| 1 | 1 | D2622-118 | EXTRUSION |
| 2 | 2 | D2734 | END PLATE |
| 2 | 2 | D3459-1 | PLATE |
| 2 | 2 | D3459-3 | PLATE |
| 3 | 3 | NAS1329C3KB130 (OR AESS10KB130) | INSERT |
| 3 | 3 | MS27039C1-07 | SCREW |
| 3 | 3 | NAS1515H3L | WASHER |
| 3 | 3 | AN960C10L | WASHER |

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 370124

TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1), PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05-11-14

| DESIGN | DRAWN BY | TITLE | REV. B |
|---------------|----------|------------------------------|--------------|
| KE | PH | DART Aerospace USA, Inc. | |
| CHECKED | APPROVED | DRAWING NO. D2842 | SHEET 1 OF 1 |
| DATE 05.09.23 | | 206L/407 FLOAT STEP ASSEMBLY | SCALE NTS |
| A | 98.10.13 | NEW ISSUE | |
| B | 05.09.23 | RE-DESIGN, ADD D3459-1/-3 | |